: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Friday, 11/18/2005 3 18 54 PM

Linda Lacelle

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 24840 - 3

Estimate Number

: 10534

P.O. Number

: NIA

This Issue Prsht Rev. First Issue

Previous Run

11/18/2005 : NC

MIA : 244341

: MACHINED PARTS

Part Number

**Drawing Name** 

: D2574

**Drawing Number** Project Number : D2574 REV D :NIA

**Drawing Revision** 

: D

Material Due Date NIP : 12/20/2005

Qty:

Each

Written By

Checked & Approved By Comment

: See comment See Comment

: Est. 2 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ

5.0. No. : NIA

Additional Product

Job Number



Seq. #

Machine Or Operation:

Description:

7075-T7351 8.25X5.0X2.5



12.0000 Each(s) 1.0000 Each(s)/Unit Total:

7075-T7351 8 25X5.0X2.5

Make from Dt 101-005 billet for D2574 Ensure that grain is along 5.00" length

Comment: Qty

HAAS1





Comment: HAAS CNC VERTICAL MACHINING #1

Program Baten No. 10 Double check by: CA 26/01/64

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per \_ No 2 p Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks -

NA (5) Tumble to remove sharp edges.

- Me Obloilog

-Me outciton

MILLING CONV

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574



4

| Dart Ae | rospace L | td                             |                      |  |                |                                     |                          | ,                        |
|---------|-----------|--------------------------------|----------------------|--|----------------|-------------------------------------|--------------------------|--------------------------|
| W/O:    |           |                                | W                    | ORK ORDER CHANGES  |                |                                     |                          |                          |
| DATE    | STEP      | PR                             | OCEDURE CHA          | NGE  | Date Q         | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC inspector |                          |
|         |           |                                |                      |  |                |                                     |                          |                          |
|         |           |                                |                      |  |                |                                     | =                        | E                        |
| Part No | :         | PAR #:                         | Fault Cate           | gory: N  | ICR: Yes (     | DQA:                                | Date: _                  | 20/101/10                |
| NCR:    |           |                                | WORK ORDI            | ER NON-CONFORMANC  |                |                                     |                          |                          |
| DATE    | STEP      | Description of NC<br>Section A | Initial<br>Chief Eng | Corrective Action Section B Action Description Chief Eng | Sign &<br>Date | Verificatio<br>Section C            | n Approval<br>Chief Eng  | Approval<br>QC Inspector |
|         |           |                                |                      |  |                |                                     |                          |                          |

NOTE: Date & initial all entries

## **Process Sheet**

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24840

Part Number: D2574

Job Number



Seq. #:

Machine Or Operation.

Description:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



-M3 06/01/09

Comment: INSPECT 5.0

SECOND CHECK



Comment: SECOND CHECK



HAND FINISHINGS

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING PESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-11

POWDER COATING





Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

PARTS AS THEY COME OFF MACHINE



80

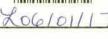
POWDER COATING

INSPECT POWDER COAT/CHEMICAL CONVERSI



Comment: INSPECT

PACKAGING RESOURCE #1



PACKAGING 1



Comment: PACKAGING RESCURCE #1

Identify and Stock Location: 373



DOCUMENT CONTROL



10.0



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



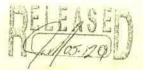
| JART AEROSPACE LTD               | Work Order:  |             |
|----------------------------------|--------------|-------------|
| Description: Saddle, Aft Inpoard | Part Number: | D2574       |
| Inspection Dwg: D2574 Rev. E     |              | Page 1 of 1 |

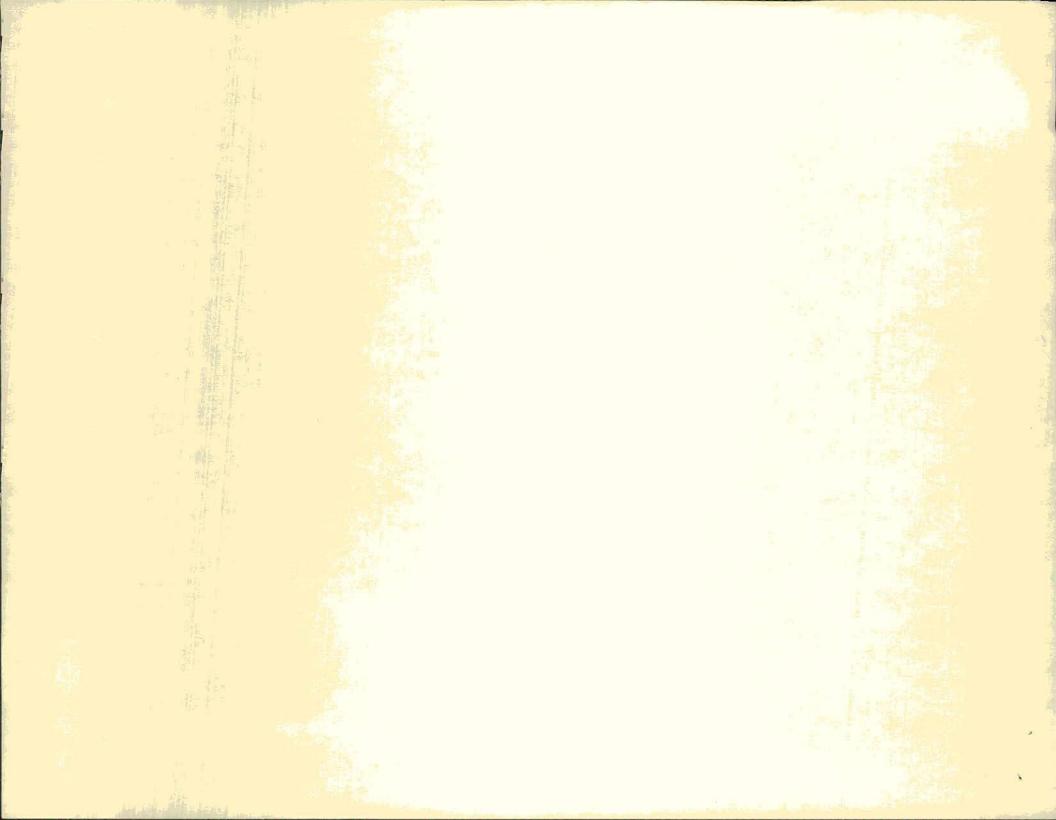
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

|          |       |           |                   | Recorded Actual Dimensions |          |          |        |    |      |
|----------|-------|-----------|-------------------|----------------------------|----------|----------|--------|----|------|
| Dim      | Min   | Max       | Go/No Go<br>Gauge | 1                          | 2        | 3        | 4      | Ву | Date |
| A        | 0.438 | 0.443     | DT8682            | 0 440                      | 1        |          | /      |    |      |
| В        | 1.745 | 1.755     |                   | 1-754                      | 1.752    | 1.750    | 1.750  |    |      |
| C        | 3.495 | 3,505     |                   | 3 50                       | 3.500    | 3.505    | 3.501  |    |      |
| D        | 1.745 | 1.755     |                   | 1.753                      | 1.751    | 1.75C    | 1750   |    |      |
| E        | 7.990 | 8.010     |                   | 49009                      | 8005     | G CC-    | £ 003  |    |      |
| F        | 0.490 | 0.510     |                   | 0.501                      | 500      | 17/21    | 205    |    |      |
| G        | 0.257 | 0.262     | DT8683            | 0.258                      | ( )58    |          | ~      |    |      |
| 1-1      | 0.375 | 0.380     | DT8684            | 0.376                      | 0.376    |          |        |    |      |
|          | 0.490 | 0.510     |                   | 0.598                      | THE RES  | PiPH     | 501    |    |      |
| J.       | 1.174 | 1.184     |                   | 1.160                      | 1.188    | V Car    | 1180   |    |      |
| K        | 0.558 | 0.578     |                   | 0-674                      | 5511     | 566      | ,510   |    |      |
|          | 1.174 | 1.184     |                   | 1.180                      | 1 80     | 1386     | 1.180  |    |      |
| îvî      | 1.365 | 1.375     |                   | 1.370                      | 1.3.11   | 1.310    | 1370   |    |      |
| N        | 2.495 | 2.505     |                   | 2-500                      | W . Se'  | 2 500    | 2.500  |    |      |
| 0        | 4.119 | 4.129     |                   | 4-133                      | 4 x (2)3 | 41122    | 4.123  |    |      |
| Р        | 0.115 | 0.135     |                   | 0 134                      | 125      | 150      | 120    |    |      |
| Q.       | 0.115 | 0.135     |                   | 0.11.0                     | 133      | 4133     | 951.   |    |      |
| R        | 0.240 | 0.260     |                   | 6.352                      | 1        | , 352    | -248   |    |      |
| S        | 0.115 | 0.135     |                   | c.193                      | v124     | 2 V 72-1 | 1125   |    |      |
| T        | 6.178 | 0.198     |                   | 0 - 1875                   | u Minte  | 5-6-     | 100    |    |      |
| Ú        | 3.210 | 3.250     |                   |                            | 1 231    | 3333     | J. 333 |    | 1.0  |
| V        | 0.230 | 0.250     |                   | 3 336                      | 144      | 240      | . 234  |    |      |
| Mi       | 0.116 | 0.135     | *                 | C ( 1- 1)                  | 131      | .135     | 126    |    |      |
| × .      | 0.307 | 0.312     |                   |                            |          |          |        |    |      |
| Y        | 0.760 | 0.765     |                   |                            |          |          | 集      |    |      |
| Z        | 0.352 | 0.372     |                   | 0.357                      | 3 11     | 1342     | 364    |    |      |
| ĀA       | 0.470 | 0.530     | -                 | U.500                      | 500      | .500     | 50°C   |    |      |
| AB       | 0.615 | 0.635     |                   | 6.633                      | 1 360    | 422      | 424    |    |      |
| AC       | 0.053 | 0.073     |                   | 0 063                      | UL 3     | (63      | ()(-3  |    |      |
| AD       | 0.240 | 0.260     |                   | 0.100                      | , 150    | 1250     | 248    |    |      |
| AE       | 1.500 | 1.520     |                   | 1.514                      | 1.511    | 1512     | 1511   |    |      |
| AF       | 0.115 | 0.135     |                   | 0-125                      | 2133     | 133      | .135   |    |      |
| AG       | 0.240 | 0.133     |                   | 6_255                      | 2132     | 253      | 1269   |    |      |
| AH       | 0.240 | 0.260     |                   | 3 - 3 - 18                 | 250      | 250      | 249    |    |      |
| -        | 2,000 | 2.020     |                   |                            |          | 1        |        |    |      |
| AI<br>AJ | 0.023 | 0.043     |                   | 3003                       | 2003     | 2003     | 7002   |    |      |
| Hu       |       | cept/Reje | CT                | Resect                     |          |          |        |    |      |

| Measured by: | Audited by | BC 66:01:10 |
|--------------|------------|-------------|
| Date:        | Date:      |             |

| Rev | Date     | Change                                  | Revised by | Approved |
|-----|----------|---|------------|----------|
| A   |          | New Issue                               | RF         |          |
| В   | 02.09.27 | Re-format; Added Rev. D                 | KJ         |          |
| C   | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ ·       |          |
| D   | 05.05.05 | Addec dimension Al                      | KJ/RF      | 11       |
| E   | 05.12.05 | Added dimension AJ                      | KJ/JLM     | 111      |





## Job Costing Report

| Cart Merospace Ltd.<br>Hawkesbury | Nov 17, 2005<br>03:30 pm     |
|-----------------------------------|------------------------------|
| wark Order No : 0024840           |                              |
| Project Name : D2574              | Department Code:             |
| Broject For : WK550               | Burden Flags : NNNNNN        |
| work Order Type : Main            | WO Status : Open             |
| Mills WO Number :                 | Invoice State : Not Invoiced |
| House Part Number : D2574         | Invoice Date :               |
| recomption : Jaddle, Aft, In      | Invoice Number :             |
| Paintractured : Yes               | Invoice Amount: 0.00         |
| convert beet's : 12               |                              |
| the stat frage to G               | Order Entry No :             |
| Start 5,ate : 11-15-05            | OE Value : 0.00              |
| 2 Fibrate Date 1                  |                              |
| Section of Parish Dates 5         | Est Margin : 0.000%          |
| no division in Research : No.     | Actual Margin : 0.000%       |
|                                   |                              |

50 Posted to Finished Goods

|                   |      | Estimated      | Actual | Var. 8 | Posted | To Post |
|-------------------|------|----------------|--------|--------|--------|---------|
| Minerial Cos:     |      | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering hours | 2    | 0.00           | 0.00   | 0.00   |        |         |
| rigineering fost  | *    | 0,00           | 0.00   | 0.00   | 0.00   | 0.00    |
| FIRST JOHN HOURS  | 8    | 0.00           | 0.00   | 0.00   |        |         |
| enparenton Cost   | - 53 | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
| rackaging hours   | 51   | 0.00           | 0.00   | 0.00   |        |         |
| rickspins Colt    | 20   | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
| menficat nous     | 7    | 0.00           | 0.00   | 0.00   |        |         |
| /er Heast / Car   |      | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
| recent re         | 10   | 0.00           | 0.00   | 0.00   |        |         |
|                   | 0    | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
| Market Harris     | 10   | 0.00           | 0.00   | 0.00   |        |         |
|                   | 100  | 0.00           | 0.00   | 0.00   | 0.00   | 0.00    |
|                   |      | 1-14 5 - 1-1-1 |        |        |        |         |
| Punden            | 0    | 0.00           | 0.00   | 0.00   |        |         |
|                   |      |                |        | Himmon |        |         |
| To al Cost        | 1    | 0.00           | 0.00   | 0.00   |        |         |
| War gin           | 1100 | 9.000          | 0.000  |        |        |         |
| Folling Cost      |      | 0.00           | 0.00   |        |        |         |
|                   |      |                |        |        |        |         |

Estimated Actual 0.00 0.00 crofits/(Loss) : 0.00 0.00